



## POWDER COATING

## Technical Data Sheet

### Highlights

PPG's Envirocyl™ and Envirocron® powder coatings are aesthetically pleasing, produce a durable uniform finish and can be custom formulated with finishes from high gloss to low gloss, and in a variety of textures.

PPG's "World Class" Acrylic Powder Coatings provide excellent durability and performance properties. This extensive line of Acrylic Powders is manufactured to meet the increasing quality requirements of the automotive, industrial and commercial industries. These sophisticated Acrylics are the solution to your smoothness, low-bake, durability and physical property requirements. An unsurpassed application development program enables consistently friendly use on a variety of substrates.

- Available in a wide range of colors and glosses
- Exterior durability
- Good chemical resistance
- Low cure capabilities
- Smooth film capabilities

### PRODUCT APPROVALS

Specifically formulated to meet the requirements of GM 9985586.

### TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated aluminum panels
Recommended Thickness	ASTM D 7091	2.0 - 4.5 mils
Curing Conditions	Metal Temperature	17 min @ 350 °F

### PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 20°	ASTM D 523	80 Minimum
Hardness	ASTM D 3363	H Pencil (Eagle)
Gravelometer	ASTM D 3170, SAE J-400	6 +
Salt spray	ASTM B 117	1000 hrs <1/8" scribe creep No blisters
Humidity	ASTM D 1735	1000 hrs <1/16" scribe creep No blisters
Water Immersion	GM 4466P GM 9071P	Pass
Filiform	GM 9682P	Pass
Cass	GM 4476P	Pass
Thermal Cycle	GM 9525 GM 9071P	Pass No Adhesion Loss
Specific gravity	Calculated	1.16 ± .05
Theoretical coverage	Calculated	166 ft <sup>2</sup> /lbs at 1.0 mil 34 m <sup>2</sup> /kg at 25 µm





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### CURING WINDOW\* (object temperature)

See Cure Curve PCC-024

40-80 min @ 300 °F (149 °C)

20-55 min @ 325 °F (163 °C)

10-35 min @ 350 °F (177 °C)

\*Temperature and time to be adjusted to accomplish proper curing of coating. This can be achieved using infrared, convection, or combination ovens.

### STORAGE STABILITY

6 months at 70 °F maximum

Materials need to be stored in sealed plastic bags under dry and cool conditions. Do not expose to sunlight.

PPG recommends that all material be used in FIFO order (first in - first out). Materials that exceed the recommended shelf life should be tested prior to use.

### SUBSTRATE PREPARATION

Surface preparation should be chosen according to the type of substrate and required performance.

The coater should test the suitability of the surface preparation before the application using appropriate test methods.

### APPLICATION RECOMMENDATIONS

Electrostatic Spray

Coating can be applied with automatic and manual devices.

Substrate should be correctly cleaned before use.

Do not mix this product with other powder coatings.

Color and finish influenced by film thickness: a good control of the film thickness will help the consistency of the aspect.

### HEALTH AND SAFETY

For comprehensive Health, Safety, and Environmental advice, please refer to the relevant Safety Data Sheets, and information printed on the product label.

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